

Date: Friday, 13/02/2009 1:02:31 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PEDAL LOCK BASE
Job Number : 45792	
Estimate Number : 11361	
P.O. Number :	Part Number : D33703
This Issue : 13/02/2009 S.O. No. :	Drawing Number : D3370 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 44288	Material :
Written By :	Due Date : 20/02/2009 Qty: 6 Um: Each
Checked & Approved By : <u>JUL 09.02.13</u>	
Comment : Est. B 05.05.25 Added Powder Coat KJ/JLM Est Rev:C 08-07-17 revC as per dwg DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1500X02500	6061-T6 Bar 1.50 x 2.50
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Comment: Qty.: 0.3657 f(s)/Unit Total : 2.1943 f(s)
 6061-T6 Bar 1.5" x 2.5"
 Material: 6061-T6 Bar (QQ-A-225/8 or QQ-A-200/8)
 (M6061T6B1.500x02.500)
 Identify for D3370-3
 Batch: M16716

mk 09/02/15

⑧

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blank: 1.500" x 2.500" x 4.120" long

mk 09/02/15

⑧

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine D3370-3 as per Folio FA482 and Dwg D3370
 Identify as D3370-3
 Dwg Rev: C

JL / mk 09/02/15

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JL / mk 09/02/15

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

85 09/02/17 ⑧

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 13/02/2009 1:02:31 PM
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Drawing Name: PEDAL LOCK BASE

Job Number: 45792

Part Number: D33703

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Handwritten signature

09/02/17

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

M102391

START TIME: *7:30am*

OVEN TEMPERATURE: *320°F*

FINISH TIME: *8:00am*

Handwritten signature

09-02-18

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 09/02/18

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

09/2/18 (S)

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/20

Job Completion



MF

09-02-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 45792
Description: Pedal Lock Cover		Part Number: D3370-3
Inspection Dwg: D3370	Rev: 8C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.00	+/-0.030	3.997	—			
3.344	+/-0.010	3.346	—			
0.592	+/-0.010	.595	—			
0.202	+/-0.010	.196	—			
Ø1.000	+0.005/-0.000	Ø1.000	✓			
0.25	+/-0.030	.260	—			
0.283	+/-0.010					
2.000	+/-0.010	1.997	—			
0.300	+/-0.010	.301	✓			
0.550	+/-0.010	.549	✓			
1.50	+/-0.030	1.497	—			
Ø1.250	+0.005/-0.000	Ø1.251	—			
0.635	+/-0.010	.635	—			
Ø0.750	+0.010/-0.000	Ø.758	—			
1.673	+/-0.010	1.669	—			
0.430	+/-0.010	.427	—			
2.638	+/-0.010	2.634	—			
2.35	+/-0.030	2.346	—			
0.715 deep	+/-0.010	.715	—			
15°	+/-0.1°	15°	—			
0.19 x 45°	+/-0.030	.190x45°	—			
0.450	+/-0.010	.441	—			
1.450	+/-0.005	1.454	—			

Measured by: <i>mf</i>	Audited by: <i>8P</i>	Prototype Approval:	N/A
Date: 09/02/15	Date: 09/04/17	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.01.05	New Issue	KJ/JLM	
B	05.04.26	Revised dimensions	KJ/JLM	
C	05.05.25	Revised dimensions	KJ/JLM	<i>[Signature]</i>

8 7 6 5 4 3 2 1

△

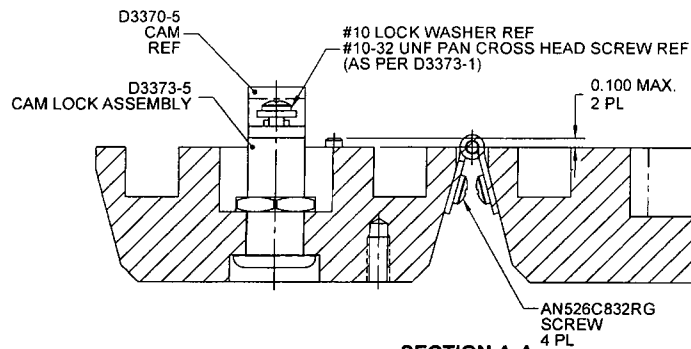
Qty. -041	Qty. -051	PART NUMBER	DESCRIPTION
X		D3370-041	TAIL ROTOR DISABLING KIT
1	X	D3370-051	PEDAL LOCK
1		D3384-041	CYCLIC SOCK
1		HX-81	1/4-20 SOCKET HEAD CAP SCREW
2		AN960-416	WASHER
	1	D2728-7	LABEL
	1	D3370-1	BASE
	1	D3370-3	COVER
	1	D3373-5	CAM LOCK ASSY
	1	D3385-3	HINGE
	2	Ø 3/16 X 0.50 GROUND STUD DOWEL PIN	GROUND STUD DOWEL PIN
	4	AN526C832R6	SCREW

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08.07.16

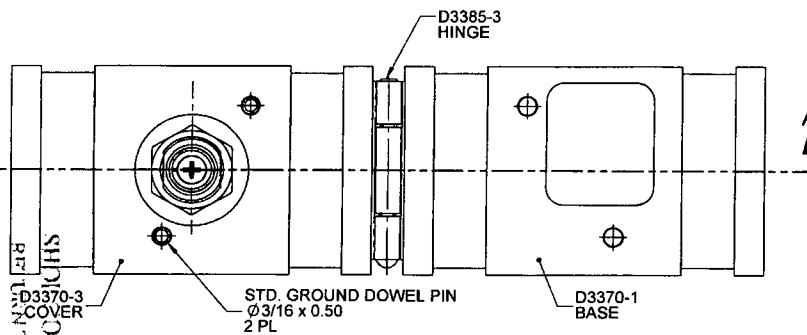
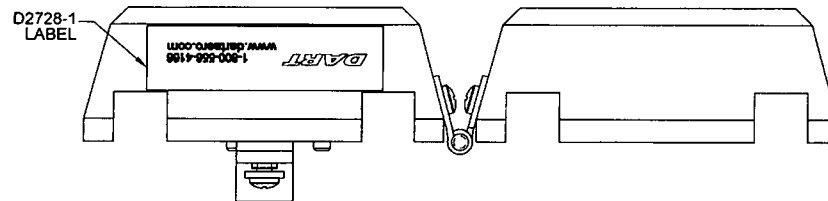
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C	SHEET 1 ADDED P/L. ADDED -041 TO P/L (SEE NCR 264). DRAWING TRANSFERRED TO "B" SIZE FORMAT. REFORMATTED TO CURRENT STANDARDS.	AJS	08.07.11
B	D3385-3 WAS D3385-1	MB	05.03.22
A	NEW ISSUE	RF	04.12.15
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3370	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		PEDAL LOCK	NTS
DATE	08.07.11	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

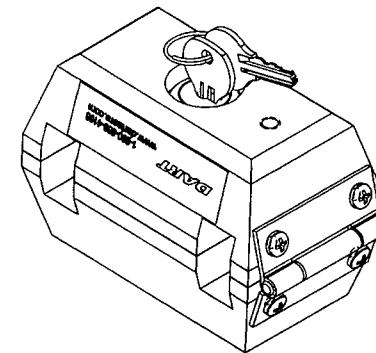
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SECTION A-A







D3370-051 PEDAL LOCK ASSEMBLY

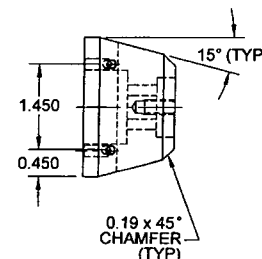
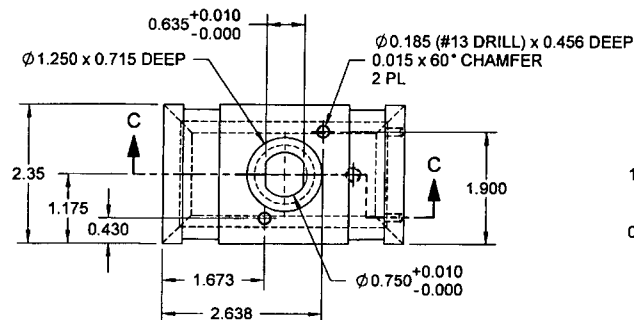
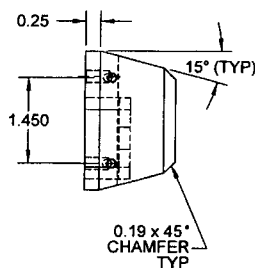
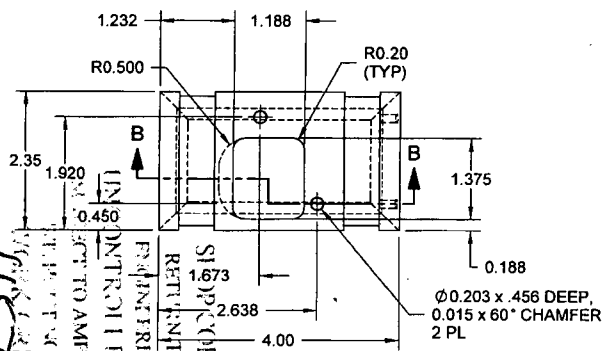
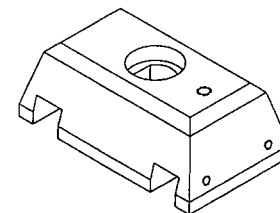
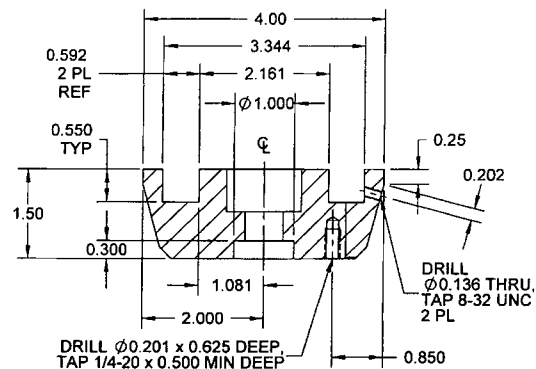
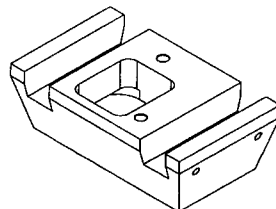
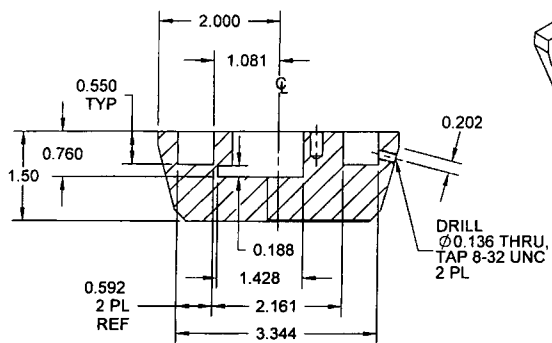


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08-07-11

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.75 lbs

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MFG. APPR.		D3370	SHEET 2 OF 4
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DE APPR.		PEDAL LOCK	NTS
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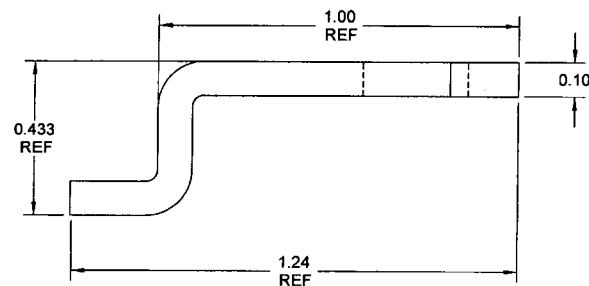
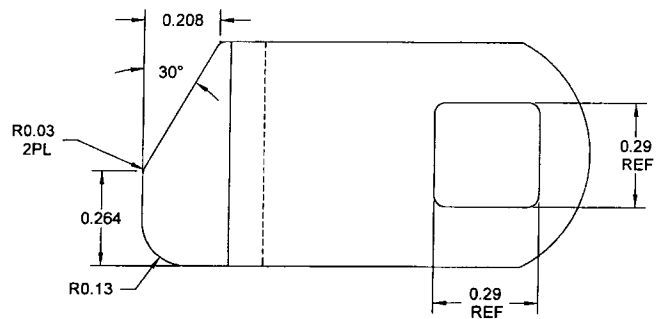
D3370-3 COVER

D3370-1 BASE

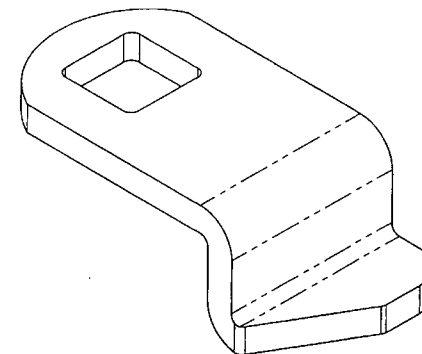
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- NOTES:
- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) REF. DART SPEC. M6061T6B
 - 2) COVER INSIDE HOLES PRIOR PAINTING
 - 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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D3370-5 CAM



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- NOTES:
 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 3) ALL DIMENSIONS ARE IN INCHES
 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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